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Dec. 21
RBE117W3-3
Job Sheet 184753



Part No: RBE117W3-3

Job Qty: *2* ea

Part Name: Frame



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/16/18

Job Tracking No:

Due Date: 11/16/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE117-W3 Rev.1 IPP Rev. A 18.10.11 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	11/16/18	11/16/18	0.00	0.00	Start Up Waterjet2		<i>18/11/08</i>
100	Waterjet - B4B	1 pcs	11/16/18	11/16/18	0.00	0.50	Waterjet 2 OMAX		<i>18/11/08</i>
110	QC	1 pcs	11/16/18	11/16/18	0.00	0.00	QC2 Waterjet-4		<i>18/11/08</i>
120	Mill Conv	1 pcs	11/16/18	11/16/18	0.25	0.13	Mill Conv 2		
130	QC	1 pcs	11/16/18	11/16/18	0.00	0.00	QC2 Machining-5		<i>18/11/21</i>
140	QC	1 pcs	11/16/18	11/16/18	0.00	0.00	QC8 Machining-5		<i>18-11-23</i>
150	Packaging	1 pcs	11/16/18	11/16/18	0.00	0.00	Packaging3-2		<i>21/12</i>
160	QC21-SA	1 Ea	11/16/18	11/16/18	0.00	0.00	QC21		<i>9-59</i> NOV 26 2018

Part Op 100 - 1-Cut as per Dwg Dwg Rev: *1* Prog Rev: *1* Ream holes if required. 2-Deburr if necessary
Descriptions: 120 - Drill 0.173" by 0.40" deep hole as per DWG.
150 - IDENTIFY AND STOCK

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M1018B0.625X10.000	1010-1025 Steel Bar .625 X 10.000	1.0800 ft (1.08 ea)	90-Start up Operation	

MT-HRS-P-0.625

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M1018B0.625X10.000	1	0	0

Part Specifications

Specifications could not be found.

DAS 03 9-59
Plex 10/16/18 2:22 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐			FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		
OTHER : ☐					



Container No: S125892



Part: RBE117W3-3

Job No: 184753

Serial No/Batch: S125892

Revision: 1

Inspector:

Exp Date:

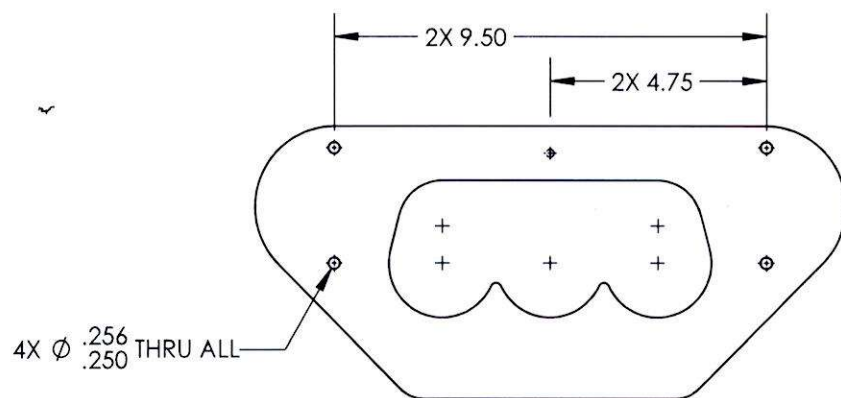
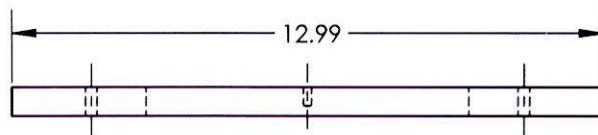
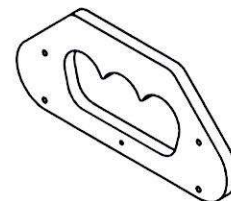
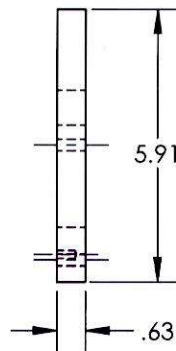
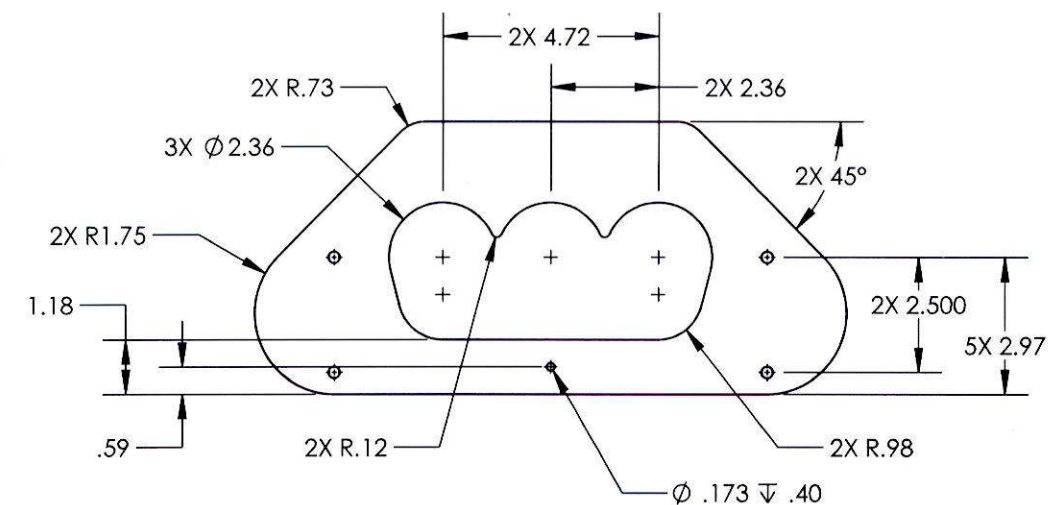
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Date: 11/09/18

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



(-3)
FRAME

SEE ATTACHED DEVIATION

DART AEROSPACE	
TITLE MAIN ROTORHEAD REMOVAL/INSTALLATION HOIST	
DWG NO. RBE117-W3-3	REV 1
MAT'L 1018/1020 CR FINISH SEE -1 WELDMENT SPEC DRAWN BY: CLOUGH CHECKED: DUERFELDT OPPTS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125° 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.6M-2009	
USED ON MODEL EC145	
SCALE 1:4	DATE 8/5/2010
SHEET 3 OF 4	